



Dart Aerospace Ltd.  
1270 Aberdeen St  
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Canada

Tel (613) 632-5200

**D350-748-243TRN**  
**Job Sheet 173676**



**Part No:** D350-748-243TRN

**Job Qty:** 1 ea

**Part Name:** Crosstube Installation, High Aft



**Part Weight:** 0 lbs

**Status:** Scheduled

**Priority:** Medium

**Job Created:** 3/6/18

**Job Tracking No:**

**Due Date:** 4/18/18

**Created By:** Michelle Gagnon-Donovan

**Type:** Stock

**Description:**

**Note:** DWG REV A IPP Rev: PRELIM New Issue LL 12.05.08

**Ship Via:**

### Bill of Materials

### Job Routing

| Op No | Operation          | Qty   | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           | Sign-off           |
|-------|--------------------|-------|------------|----------|-----------|---------|-----------------------|-----------|--------------------|
|       |                    |       |            |          | Setup hrs | Run Hrs | Workcenter / Supplier | Lead Time |                    |
| 90    | Start up Operation | 1 Ea  |            | 4/17/18  | 0.00      | 0.00    | Start Up Crosstubes-1 |           | PMP                |
| 100   | Mori Seiki         | 1 pcs |            | 4/17/18  | 2.01      | 3.57    | Mori Seiki TL-40      |           | PMP                |
| 110   | QC                 | 1 pcs |            | 4/17/18  | 0.00      | 0.00    | QC2-1                 |           | PMP                |
| 120   | Mori Seiki         | 1 pcs |            | 4/17/18  | 0.00      | 3.57    | Mori Seiki TL-40      |           | PMP                |
| 130   | QC                 | 1 pcs |            | 4/17/18  | 0.00      | 0.00    | QC2-1                 |           | PMP                |
| 140   | QC                 | 1 pcs |            | 4/17/18  | 0.00      | 0.00    | QC8                   |           | GP                 |
| 150   | Crosstubes         | 1 pcs |            | 4/18/18  | 0.00      | 0.81    | Crosstubes-2          |           | GP                 |
| 190   | Packaging          | 1 pcs |            | 4/18/18  | 0.00      | 0.00    | Packaging3-1          |           | GP                 |
| 200   | QC21-SA            | 1 Ea  |            | 4/18/18  | 0.00      | 0.00    | QC21                  |           | DAS 21 APR 17 2018 |

Part Op 100 - 1-Cut tube on chop saw, leave extra mat'l for facing and install plugs 350-241 on both ends. 3- Turn program 02000 Descriptions: section on both side as per folio FB468. 4- Turn program 03000 section on both side as per folio FB468.

120 - 1- Turn program 04000 section on both side as per folio FB468. 2- Turn program 05000 section on both side as per folio FB468. 3- Blend transition lines only with belt sander 60 grit 4-Scribe part # as per Dwg D350-748-243

130 - PERFORME ULTRASONIC MEASUREMENT

150 - 1-Grind machining marks

190 - Identify and stock in kanban rack

### Job BOM

| Part / Item | Component Name                 | Quantity    | Operation             | Container |
|-------------|--------------------------------|-------------|-----------------------|-----------|
| D6021-125   | Crosstube Material - 17-4Ph SS | 1 Ea (1 ea) | 90-Start up Operation |           |

### Job Allocations

| Operation             | Component Part | Required | Inventory | Allocated |
|-----------------------|----------------|----------|-----------|-----------|
| 90-Start up Operation | D6021-125      | 1        | 71        | 0         |

6127272

### Part Specifications

Specifications could not be found.

Plex 3/6/18 12:37 PM Dart.Gagnon.Michelle



**Container No: S057892**



**Part: D350-748-243TRN**

**Job No: 173676**

**Serial No/Batch: S057892**

**Revision:**

**Inspector:**

**Dart Aerospace Ltd.**  
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www.dartaerospace.com

Date: 04/03/18

|                                                                |  |                                  |
|----------------------------------------------------------------|--|----------------------------------|
| <b>DART AEROSPACE LTD</b>                                      |  | <b>Work Order:</b> 173676        |
| <b>Description:</b> Crosstube Assembly (AS350/355 High Aft SS) |  | <b>Part Number:</b> D350-748-243 |
| <b>Inspection Dwg:</b> D350-748-243 Rev: A                     |  | <b>Page 1 of 2</b>               |

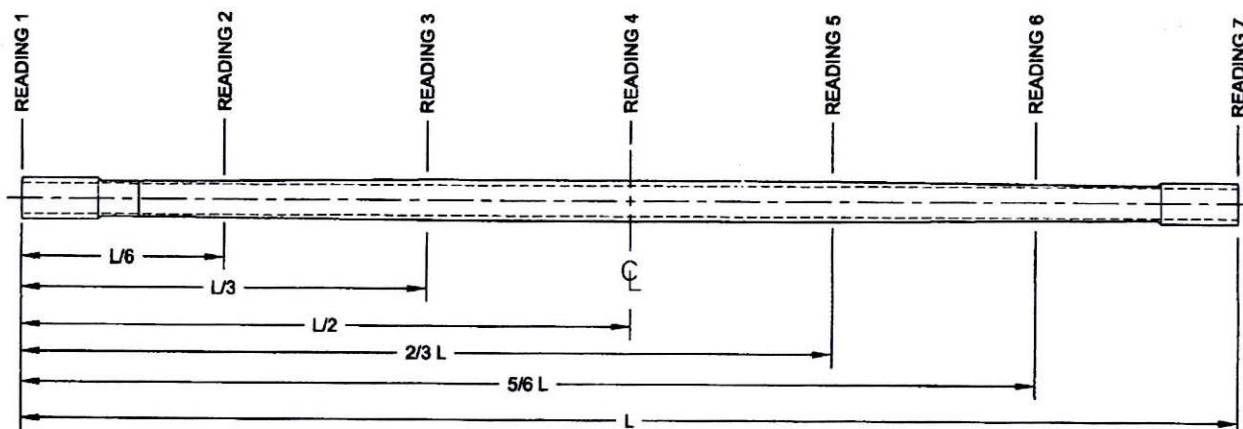
### FIRST ARTICLE INSPECTION CHECKLIST

|        | Inspection Sheet<br>Drawing Dimension | Tolerance     | Actual<br>Dimension | Accept | Reject | Method of<br>Inspection | Comments |
|--------|---------------------------------------|---------------|---------------------|--------|--------|-------------------------|----------|
| SIDE A | 2.240                                 | +/-0.005      | 2.243               | ✓      |        | VERN 08                 |          |
|        | 2.180                                 | +0.005/-0.000 | 2.184               | ✓      |        | BLM 2"-3" 04            |          |
|        | 2.180                                 | +0.005/-0.000 | 2.184               | ✓      |        |                         |          |
|        | 2.208                                 | +0.005/-0.000 | 2.212               | ✓      |        |                         |          |
|        | 2.234                                 | +0.005/-0.000 | 2.239               | ✓      |        |                         |          |
|        | 2.253                                 | +0.005/-0.000 | 2.257               | ✓      |        |                         |          |
|        | 2.272                                 | +0.005/-0.000 | 2.277               | ✓      |        |                         |          |
|        | 2.299                                 | +0.005/-0.000 | 2.306               | ✓      |        | BLM 2"-3" 04            |          |
|        | 0.063                                 | +/-0.010      | .063                | ✓      |        | RG                      |          |
|        | 5.25                                  | +/-0.060      | 5.258               | ✓      |        | VERN 08                 |          |
|        | R0.063                                | +/-0.010      | .063                | ✓      |        | RG                      |          |
|        | R0.50                                 | +/-0.030      | .502                | ✓      |        | RG                      |          |
|        |                                       |               |                     |        |        |                         |          |
|        |                                       |               |                     |        |        |                         |          |
| SIDE B | 2.240                                 | +/-0.005      | 2.245               | ✓      |        | VERN 08                 |          |
|        | 2.180                                 | +0.005/-0.000 | 2.185               | ✓      |        | BLM 2"-3" 04            |          |
|        | 2.180                                 | +0.005/-0.000 | 2.185               | ✓      |        |                         |          |
|        | 2.208                                 | +0.005/-0.000 | 2.213               | ✓      |        |                         |          |
|        | 2.234                                 | +0.005/-0.000 | 2.239               | ✓      |        |                         |          |
|        | 2.253                                 | +0.005/-0.000 | 2.258               | ✓      |        |                         |          |
|        | 2.272                                 | +0.005/-0.000 | 2.277               | ✓      |        |                         |          |
|        | 2.299                                 | +0.005/-0.000 | 2.306               | ✓      |        | BLM 2"-3" 04            |          |
|        | 0.063                                 | +/-0.010      | .063                | ✓      |        | RG                      |          |
|        | 5.25                                  | +/-0.060      | 5.261               | ✓      |        | VERN 08                 |          |
|        | R0.063                                | +/-0.010      | .063                | ✓      |        | RG                      |          |
|        | R0.50                                 | +/-0.030      | .50                 | ✓      |        | RG                      |          |
|        |                                       |               |                     |        |        |                         |          |
|        |                                       |               |                     |        |        |                         |          |
|        | 124.70                                | +/-0.060      | 124.7               | ✓      |        | TAPE                    |          |



|                                                                |                                  |
|----------------------------------------------------------------|----------------------------------|
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### WALL THICKNESS MEASUREMENT



| Location               | WALL THICKNESS MEASUREMENT (IN) |     |     |     | Deviation<br>$\Delta w$<br>(max-min) | TOLERANCE |
|------------------------|---------------------------------|-----|-----|-----|--------------------------------------|-----------|
|                        | w1                              | w2  | w3  | w4  |                                      |           |
| READING 1<br>L= 0"     | 125                             | 123 | 123 | 128 | -.005                                | 0.030"    |
| READING 2<br>L= 20.78  | 112                             | 114 | 115 | 116 | -.004                                |           |
| READING 3<br>L= 41.57  | 155                             | 157 | 156 | 157 | .002                                 |           |
| READING 4<br>L= 62.35  | 155                             | 156 | 159 | 157 | .004                                 |           |
| READING 5<br>L= 83.13  | 158                             | 155 | 154 | 152 | .006                                 |           |
| READING 6<br>L= 103.92 | 122                             | 115 | 110 | 115 | -.012 PMP                            |           |
| READING 7<br>L= 124.7  | 124                             | 126 | 125 | 125 | -.002                                |           |

#### Calibration Result

Actual Block Thickness: 100 100

Sitiescan 250 Measured Thickness: 100 200

|                     |  |                    |  |                              |  |
|---------------------|--|--------------------|--|------------------------------|--|
| <b>Measured by:</b> |  | <b>Audited by:</b> |  | <b>Preliminary Approval:</b> |  |
| Date:               |  | Date:              |  | Date:                        |  |
| Rev                 |  | Date               |  | Change                       |  |
| A                   |  | 15.09.09           |  | New Issue                    |  |

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SUBJECT TO AMENDMENT

WITHOUT NOTICE  
WORK ORDER  
NO. 173676 *ms*  
MAR 06 2018

